

Work Order ID 163447

Tuesday, June 27, 2017 1:12:39 PM

163447

Page 1

Item ID: D4095-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearplate Aft
 Start Date: 6/27/2017 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 7/6/2017 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: 21 Date: JUN 28 2017 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4095	D								
100	FLOW WATER JET	0.01							
100									
Waterjet	Memo	0.59							
FLOW CNC Waterjet	1-Cut as per Dwg (D4095-3) Dwg Rev: <u>D</u> Prog Rev: <u>D</u> 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.04							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.08							
Quality Control									

(4) _____ 06/27/2017

(4) _____ 06/27/2017

4 _____ **DAS**
38
9-89
JUL 06 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval _____	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

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 Start Date: 6/27/2017 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 7/6/2017 Req'd Qty: 4.00 ***4*** Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	Form as per dwg NC BRAKE Memo 1- bend section C-C first 2- Form on Brake as per Dwg D4095 using Jigs DT 8179 and DT 8155 3- Form Joggles (2) as per Dwg D4095 on brake using Jig DT 8157	0.43 0.43				4	Ø	JUL 17 2017	DAS 19 9-00
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo Ensure joggle as per dwg D4095	0.00 0.08				4		JUL 18 2017	DAS 38 9-00
150 *150* autoweld 1 Automated Welding 1	Weld per dwg & QSI004 4.5 Large Fab Memo ***SEE NOTE 8 FOR SURFACE BUILDUP*** 1- WELD AS PER DWG AND QSI004 4.5 FOR AUTOMATED WELDING USE 8259 HARDCOAT BATCH: <u>M132414</u>	0.00 1.82				4	Q.L	17-07-24	

17-7-3

DQA: _____ Date: _____

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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
2013 11/11 11/11				Completed By	
				Lead hand / Supervisor Approval Verification	
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AUG 02 2017

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1.4 0 8.4				Lead hand / Supervisor Approval Verification	
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Root Cause		FAULT CATEGORY			
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC3- Inspect Part Finish	0.00							
190									
QC	Memo	0.04				4			DAS 38 AUG 03 2017
Quality Control									
200	Identify as per dwg & Stock Location: <u>FP-002</u>	0.00							
200									
Packaging	Memo	0.04				x4	d	12/09/10	
Packaging	LOCATION : FP002								
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.40							17/8/9
Quality Control									

DAS
21
9-89

AUG 03 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																			
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Picklist Print

Tuesday, June 27, 2017 1:12:41 PM

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Work Order ID: 163447

163447

Parent Item: D4095-043

D4095-043

Parent Item Name: Wearplate Aft

Start Date: 6/27/2017

Required Date: 7/6/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A new issue DD 10.04.26 verified by:EC
15.10.29 AUTOMATED WELDING DD VERF:JLM

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased		No		100	sf	109.3820	2.275	9.578947			

M304S16GA

304/316 Sheet .063

06/17/17/06/17

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT010	109.382	
m136896	0.3	
m137110	0.532	
m137175	1.1	
m137341	2.62	
m137400	40.83	
m137844	64	

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DQA: _____ Date: _____



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OTHER : _____					

DART AEROSPACE LTD		Work Order: 163447
Description: Wearplate		Part Number: D4095-043
Inspection Dwg: D4095 Rev: ED		Page 1 of 1

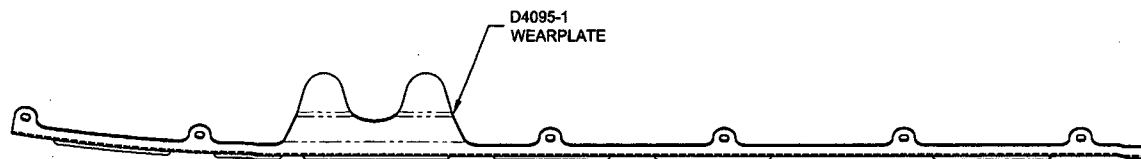
INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.19	+0.005/-0.001	Ø .189	1		V: D-02	
2.43	+/-0.030	2.43	1		Top	
2.50	+/-0.030	2.50	1			
3.227	+/-0.010	3.225	1			
4.06	+/-0.030	4.06	1			
4.98	+/-0.030	4.98	1			
6.00	+/-0.030	6.00	1			
8.43	+/-0.030	8.43	1			
12.10	+/-0.030	12.10	1			
19.25	+/-0.030	19.25	1			
22.75	+/-0.030	22.75	1			
30.00	+/-0.030	30.00	1			
36.00	+/-0.030	36.00	1			
38.87	+/-0.030	38.87	1			
9.0	+/-0.100	9.0	1			
20.5	+/-0.100	20.5	1			
26.8	+/-0.100	26.8	1			
0.063	+/-0.010	.059	1			
0.300	+/-0.010	.299	1			
0.300	+/-0.010	.300	1			
.395	+/- .010	.396				
.395	+/- .010	.396				

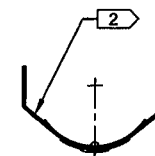
Measured by: DE	Checked by: 38	QC Inspector:
Date: 17/07/06	Date: JUL 06 2017	Date:

Engineering Approval: (If necessary)	Date:
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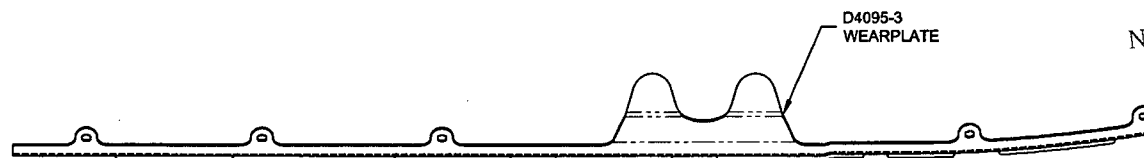
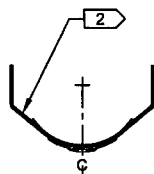
Rev	Date	Change	Revised by	Approved
A	16.02.19	New Issue	KJ	



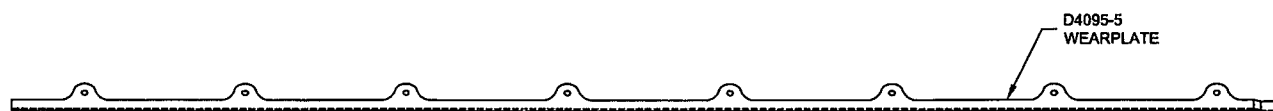
D4095-041 WEARPLATE ASSEMBLY



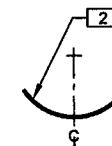
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1206-28



D4095-043 WEARPLATE ASSEMBLY

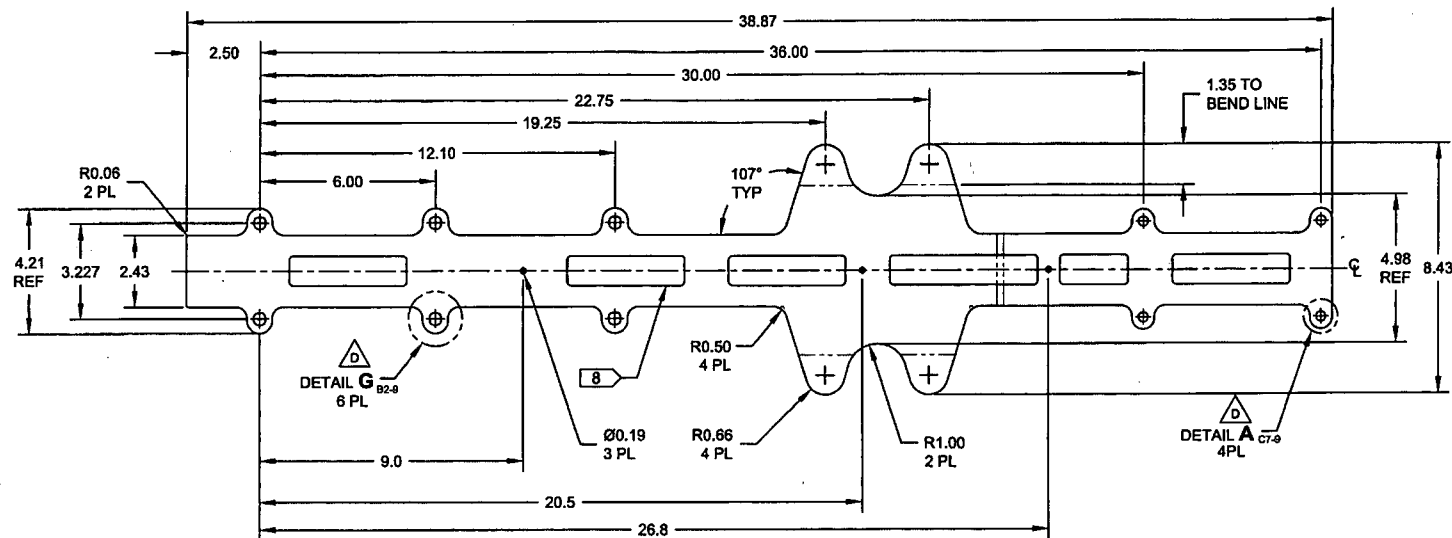


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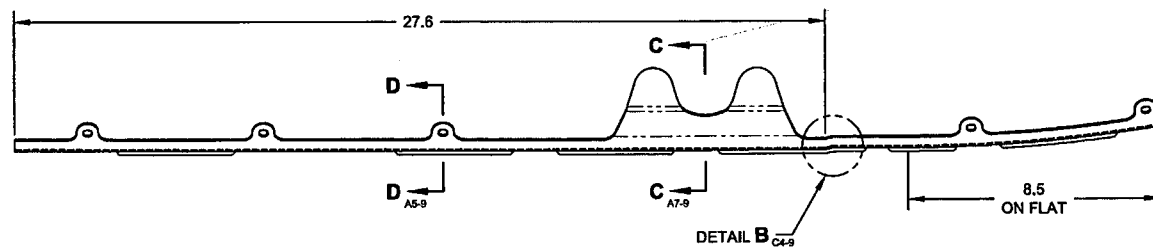


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DESIGN	MB	DART AEROSPACE USA, INC	
DRAWN	AJS	EUGENE, OR	
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MFG. APPR.	DD	D4095	SHEET 2 OF 9
APPROVED	WM	TITLE	SCALE
DE APPR.	#	WEARPLATE	NTS
DATE	16.05.06	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



D4095-3F FLAT PATTERN 1



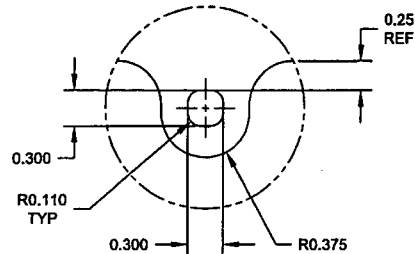
D4095-3 BENDING DETAIL
(MAKE FROM D4095-3F)

D4095-3 NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316), OR ASTM A240 OR ASME SA240
REF DART MATERIAL SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: BUILDUP HARD SURFACING 0.17 TO 0.20 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR
BUILDUP HARD SURFACING 0.17 TO 0.20 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)
- 9) PARTS ARE SYMMETRIC ABOUT CENTERLINE

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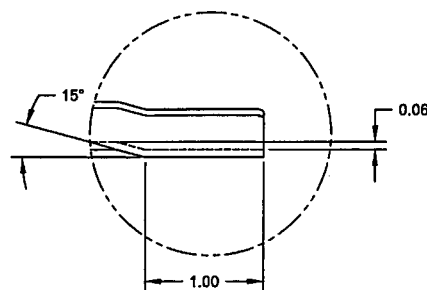
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MFG. APPR.	DD	D4095	SHEET 5 OF 9
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DETAIL A: TAB DETAIL

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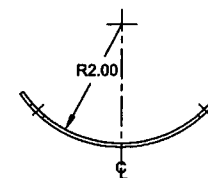
C3-4
C2-5
C6-7
D2-8



DETAIL B: JOGGLE DETAIL

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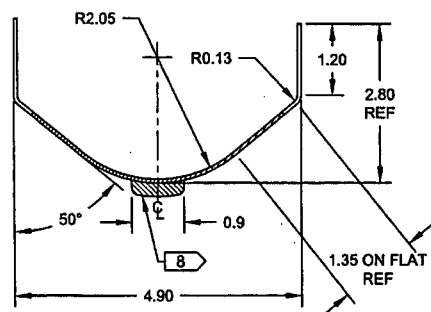
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B3-5
B2-7



SECTION E-E

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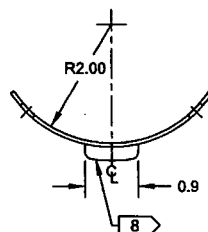
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SECTION C-C

SCALE 2X

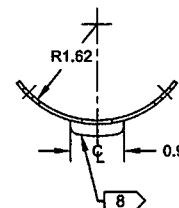
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SECTION D-D

SCALE 2X

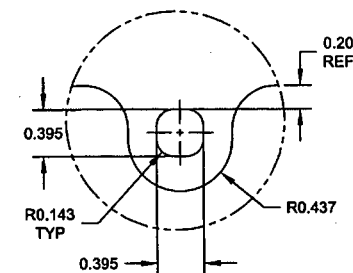
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B5-5



SECTION F-F

SCALE 2X

B5-6
B7-6



DETAIL G: TAB DETAIL

SCALE 4X

C6-5
C4-7

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